Work Orde		00468	<u>/</u>	*100	1468*		, = <u> =</u>				Page 1
Item ID: Revision ID: Item Name:	647.2511 Nut 4/22/13	Start Qty: 100 Req'd Qty: 100	10 ⁰	Accept	*N900 Cust Item II Customer:		100)* s	etup Star	IV	S1* S2*
Approvals:		an: ML5	Date: \3 \04\-			te:		R	tun Star Stop	!71	R1* R2*
Sequence ID/ Work Center II	, , , , , , , , , , , , , , , , , , ,	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr									
647.2500	N/0	C .	·								
100		DOOSAN LATHE		0.00	13.5	, 4		10	\$		OAS 04 9-89
Doosan Doosan Lathe		Memo 1 - Turn as p DWG Rev: FOLIO RevDeburr per	NA	0.00 WG	·		\		··· — - 		
*110		QC2- Inspect parts off n	nachine FAI/FAIB	0.00	13.5	5.4		10	4		OAS 04 9-8
QC Quality Control		Memo		0.00						·	

								DQA:	Date:	
NCR: Y	es /	No	,		WORK ORDER NON-C	ONFORM	MANCE / UPDATE	QA Closed:	Date:	
Work Orde	er:				DISPOSITION		AGAII Skid-tube Crosst	NST DEPARTMENT	/PROCESS Water Jet	Engineering
Part N				<u> </u>	Scrap Use-as-is Work Order Update	l i	Machining Small noforming Finish Large Fab Compo	Fab Pro	re/Packaging Supplier	Quality Other
Root					Description of work order update	Initial	Action	Sign &		
Cause	D	ate	Step	Qty	or Non-conformance	Chief Eng	Description	Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling			,]				
Operator			7			ļ				
Material			i		ł	 				
Setup						}				
Other									:	
Process					Į į					
Supplier										

FAULT CATEGORY Landing Gear General Ovalized Pressure/Forced Bend Grain Bending Temperature/Cure Over/Under tolerance Centre Not Concentric to O/S BOM/Route Hardware Broken/Damaged Part Incorrect Weld Inspection Incomplete Cracks Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Crushed/Crimped Burrs Cuffs Contamination Maintenance Part Moved Positioned Wrong Countersink Mislabeled Heat Treat Other Power Loss/Surge Inspection Strip in Tube Misread Cut Too Short Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Finish Out of Sequence Turning Sequence Folio Outside Dimensions Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Training Unapproved

Work Ord		00468		*100)468*					Page 2
Item ID: Revision ID: Item Name:	647.2511 Nut			Accept	*N900	04010	n *	Setup Start	14.	S1*
Start Date: Required Date: Reference:	4/22/13 : 4/22/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item l Customer:	ID:			14.	
Approvals:	Process Pl	lan:	Date:	Tooling: _ SPC (Y/N):		ate:	1	Run Start Stop	"1711	₹1* ₹2*
Sequence ID/ Work Center I 140 *140* QC Quality Control	D	Operation Description QC8- Inspect parts - second Memo 100% CHEC		Set Up/ Run Hours 0.00 0.00 SIONS AND THREAD F	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp O8
*150 *150* Purchasing Purchasing			oer MIL-S-5002 TYPE 6 of conformaty is required	0.00	·		Co	L 13/09	5/08	(10)
160 *160* Packaging		Receive & Inspect for Do	amage & Mat'l Certs	0.00				/43	r 6] -7	, (1)

Packaging

Ensure certificate of conformity is attached

es / No		1		WORK ORDER NON-C	ONFO	ORN	//ANCE / UPDATE			2		·
		:							QA Closed:	Dat	te:	
ri:		,		DISPOSITION		-	AGAINS	T DE	PARTMENT,	/PROCESS		
				Rework Scrap Use-as-is Work Order Update	TI	N herm	Machining Small Fa	b g	1	d. Eng. Coor. e/Packaging		Engineering Quality Other
1	<u> </u>		Descri	ption of work order update	Initi	al	Action		Sign &		T	
Date	Step	Qty		•	i		Description		Date	Verification	n 📗	QC Inspector
			***		AULIC	AIE	JURY					<u></u> , , ,
Bending Centre N Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in n Bend Vaves in I	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Hallins Ins Ma Mi Mi Off	rdwar pection truction ainte slabe sread fset t of C	on Incomplete ions Incomplete/Unclear nance led Calibration		Part Incorred Part Lost/Mi Part Moved Positioned V	ct ssing Vrong	* * * * * * * * * * * * * * * * * * *	ressure/Forced emperature/Cure Veld Vrong Stock Pulled Other
	Date Date Date Bending Centre N Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque V	Date Step Date Step	Date Step Oty Date Step Oty Bending Centre Not Concentric to C Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend	ng Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance Fing Gear General Bending Bend BoM/Route Centre Not Concentric to O/S Broken/Damaged Cracks Broken/Damaged Crushed/Crimped Burrs Cuffs Contamination Cuffs Contamination Cuffs Contamination Heat Treat Countersink Inspection Strip in Tube Ripples in Bend Drill Holes Torque Waves in Extrusion Drawing	Table 1	DISPOSITION Rework Scrap Use-as-is Work Order Update Initial Chief Eng Date Step Qty Description of work order update Or Non-conformance Chief Eng Date Step Qty Description of work order update Or Non-conformance Chief Eng FAULT CATE Gear General Bend Grain Bending Bend Grain Centre Not Concentric to O/S BOM/Route Hardwa Cracks Broken/Damaged Inspection Crushed/Crimped Burrs Instruct Cuffs Contamination Mainte Cuffs Contamination Mainte Cuffs Countersink Mislabe Inspection Strip in Tube Cut Too Short Misread Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Countersing Drawing Out	DISPOSITION Rework Skid-tube Crosstube Small Factor Small Factor Composite Composite	DISPOSITION Rework Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Composite	AGAINST DEPARTMENT, Skid-tube Machining Small Fab Pro No.	DISPOSITION Rework Scrap Use-as-is Work Order Update On Non-conformance Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Date Date	DISPOSITION Rework Skid-tube Crosstube Machining Small Fab Prod. Eng. Coor.

Outside Dimensions

Date:

Wave/Twist in Tube

Folio

Work Orde		00468		*1004	168*		1900 1 710 T					Page 3
Revision ID:	647.2511 Nut	 		Accept	*N900	040	100)*	Setup	Start Stop	*N: *N	S1* S2*
	4/22/13 4/22/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:		lan:		Tooling:		ate:			Run	Start Stop	*N	R1*
Sequence ID/ Work Center II 170 *170* QC Quality Control	QC:	Operation Description QC5- Inspect part comp	Date:	SPC (Y/N): Set Up/ Run Hours 0.00 SMA 0.00 13 5	Tool ID	Tool #	Plan Code	Accept Qty	Reç Qt		Reject Number	Insp. Stamp
*180 *180* Packaging Packaging		Identify as per dwg & St Memo	ock Location: 57 5	3 (c 0.00 0.00				<u>(</u> ©	<u> </u>			3-5-17
190 *190* QC		QC21- Final Inspection Memo	- Work Order Release	0.00						13/	5/21	4)

Quality Control

mp 13-5-21

			1							DQA.	Date.	
NCR:	Yes / No				WORK ORDER NON-C	100	NFORM	ANCE / UP	DATE			-
	,		<u> </u>			_				QA Closed:	Date:	
Work Orde	oř.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orac					Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	No.				Scrap		r	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	No				Work Order Update			Large Fab	Composite	j	Supplier	
Root				Descri	ption of work order update	П	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												,
Equip/Tooling										•		
Operator											·	
Material										<u> </u>		
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Other]										
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Unapproved	<u> </u>		<u>.</u>							<u> </u>		
					F.	AUL	T CATE	GORY				
Landi	ng Gear	1		_	General		7			7		i
	Bending	.]		L	Bend		Grain			Ovalized		Pressure/Forced
	Centre I	Not Conce	entric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorred	ct	Weld
	Crushed	/Crimped	ł	L	Burrs		4	ions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
•	Heat Tro	eat			Countersink		Mislabe	led		Positioned V	Vrong	-
	Inchecti	on Strin i	n Tuha		Cut Too Short	1	Misreac			Power Loss/	Surge	Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

April-22-13 1:41:07 PM

Work Order ID:

100468

Parent Item:

647.2511

Parent Item Name:

Nut

Start Date: 4/22/13

Required Date: 4/22/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M174PH-H1150R1.000		Purchased	No				f	0.0000		0.052631	5			
17-4 SS H1150 ROUND B	3AR 1.000										~ × × * * *			

M123450

666

13.5.4

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Page 1

DQA:	Date:		
	 -		-

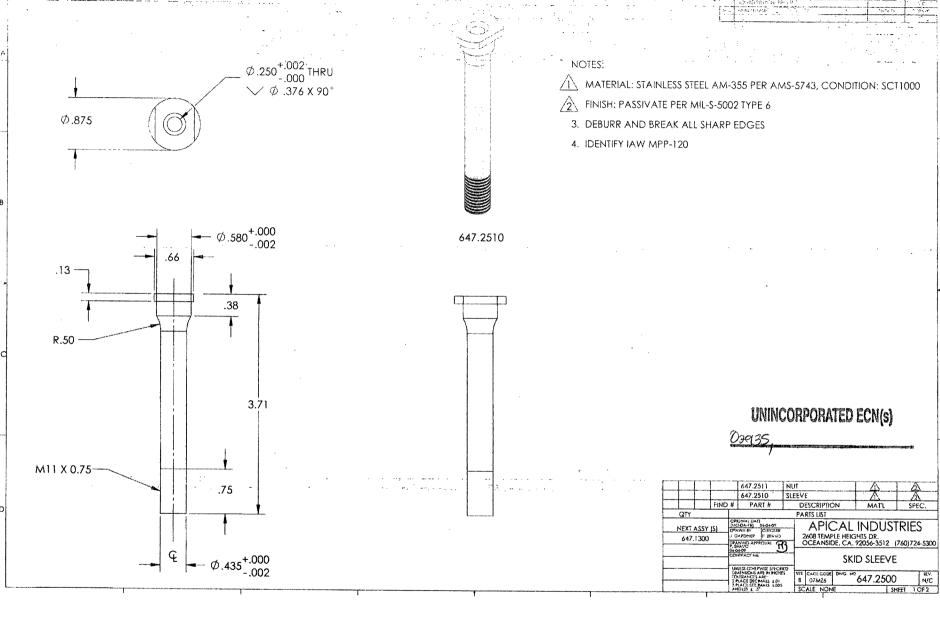
NCR: Yes / No

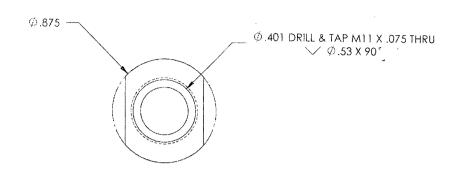
WORK ORDER NON-CONFORMANCE / UPDATE

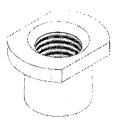
		,									QA Closed:	Dat	te:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
Part N	 					Rework Scrap Use-as-is		ı	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR N	No					Work Order Update]	l.	Large Fab	Composite		Supplier		
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification		QC Inspector
Doc/Data			1											
Equip/Tooling				i i										
Operator	Ш			!										
Material	Ш						1							•
Setup														
Other														
Process														
Supplier														
Training			1 1											
Unapproved							L				<u> </u>			
						F.	AUL	T CATE	GORY					
Landi	ng Go	ear				General		_			•			
	∐E	Bending	1			Bend		Grain			Ovalized	ļ		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance		Temperature/Cure
		Cracks	}			Broken/Damaged	L	Inspecti	on Incomplete	L	Part Incorred	it [Weld
		Crushed/0	Crimped			Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/Mi	ssing		Wrong Stock Pulled
	П	Cuffs	1			Contamination		Mainte	nance		Part Moved			
	Πŀ	Heat Trea	t			Countersink		Mislabe	led		Positioned W	/rong		
		nspection	n Strip in	Tube		Cut Too Short		Misread	ı		Power Loss/	Surge		Other
	_	Ripples in				Drill Holes		Offset						
	\prod_{i}	Torque W	aves in I	Extrusio	n	Drawing		Out of 0	Calibration					
		Furning S	equence	:		Finish		Out of S	Sequence					
	\Box	Wave/Tw	ist in Tul	be		Folio		Outside	Dimensions					

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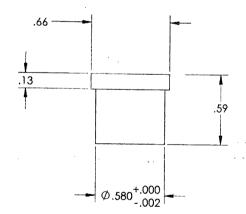
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e i jakenia.		ENGINEERING CHANGE NOTICE NO. 02935	SHEE.	T 1: OF A
	APICAL	POTRACE CONTRACTOR OF THE POTRACTOR OF THE POTRACE CONTRACTOR OF THE POTRACTOR OF THE	DATE: 07/14/10	EFFECT ON DWG
	INDUSTRIES, INC.	DWG TITLE: SKID SLEEVE	1 2	1 C 1140. (M 0141140)
		APPROVED BY ENGRY Saw MFG Davy Paul Quan	ull Jem EFF:	CURRENT ORDER
	TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED PART MATERIAL		
	2 FINISH: 3. DEBURR	PASSIVATE PER MIL-S-5002 TYPE 6 AND BREAK ALL SHARP EDGES Y IAW MPP-120	UNCONSIA SIL, COLL MARK	13-04-25 IS
177		ting the second of the second	tana in 1998 - Tanan Sangaran	
,	FIN TO PART NUMBER	DESCRIPTION MA	ATERIAL SPE	CIFICATION
	DOCUMENTS EFFECTED:	☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ B☐M ☐ MAJ□R ☒ N	GORY DER REVIEW R	







647.2511



ORGINAL DATE (MOSIA-YR) DEGLES BRAWN BY CHICKER 1 GARDYER P. FRAYO	APICAL 2608 TEMPLE HEIG	INDUSTRIES
DRAWING APPROVAL P. BRAYD	OCEANSIDE, CA.	92056-3512 (760)724-530
COMIRACT NO.	SKI	D SLEEVE
UNIESS OTHERWISE SPECKED OMAENSOMS ARE REPORTED FOLERANCES ARE 2 PLACE DECRMAIS ± 01 3 PLACE DECRMAIS ± 015	SUF CAGECODE DIVID. NO B 07M26	647.2500 N/C
ANCHES & S.	SCALE: NONE	SHEET 2 OF 2

DART AEROSPACE LTD	Work Order: 100 160
Description: NUT	Part Number: 647. 25/
Inspection Dwg: Rev: N/C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
. 875.	+/005		-		EP SL	
, 40/ 4	1.006-00/					
. 53 x	+1010					
90 ;	1/2.					
. 66	+/010					
. 13	1/ -010					
. 59	t/010					
.580	10002					
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· · · · · · · · · · · · · · · · · · ·						
,						
	OAS					

Measured by:	8-80	Audited by:		Preliminary Approval:	
Date:	13.5.4	Date:	13/05/06 9-89	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62385

Date: 17-May-13

То

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

			FII. 013-032-5200	Fax: 613-632-1185	
Terms		Ship Via			
Quantity	Description				
lot	Part: ASST 10 PCS 647.2511 PASSIVATE PER QQ-P-35 MINIMUM RUN 1 PC D4824-1 1 PC D4842-4 1 PC D4838-2		Rev:		
	1 PC D4842-1 1 PC D4842-3 1 PC D4823-1 1 PC D4838-1 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2	01.400.41			
	PRIME PER MIL-P-23377J TYPE I Job: 20130292	PO: 19816	Line:		
	Certificate of Con	formance			
	A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.				
	ISO 9001 : 2008 REC ATG SALES-2010 TE DATE : 7/5/3	GISTERED ERMS APPLY			
	CERTIFIED SIGNATURE :				
	RECEIVER SIGNATURE :		-		